

Date: Monday, 02/06/2008 4:32:28 PM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	STIFFENER
<b>Job Number</b> :	39639		
<b>Estimate Number</b> :	10481		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2353
<b>This Issue</b> :	02/06/2008	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2353 REV.C
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	36851	<b>Drawing Revision</b> :	C
	<b>Type</b> :	<b>Material</b> :	
	SMALL /MED FAB	<b>Due Date</b> :	10/06/2008
<b>Written By</b> :		<b>Qty:</b>	20
<b>Checked &amp; Approved By</b> :	JUD 08.6.02	<b>Um:</b>	Each
<b>Comment</b> :	Est Rev: A Removed from 9 Digit 05-11-10 EC		
	Est: B 06.11.15 waterjet EC		
	est: c 06.12.07 ecn 836 ec		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S050	2024-T3 .050 sheet
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**Comment:** Qty.: 0.1536 sf(s)/Unit Total : 3.0723 sf(s)  
 Material: 2024-T3 .050 sheet  
 Aluminum (QQ-A-250/5)  
 Batch: 105646

IB 8-6-9

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D2353  
 Dwg Rev: C  
 Prog Rev: C

IB 8-6-9

2-Deburr if necessary

IB 8-6-9

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

**Comment:** SECOND CHECK

S 08/06/09

counters

(25)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 02/06/2008 4:32:28 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STIFFENER

Job Number: 39639

Part Number: D2353

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend per Dwg D2353

SD 08/06/11

(25)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 08/06/11 (25)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD 08/06/11 (25)

8.0

POWDER COATING

POWDER COATING



M 102316



(25X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

10:40 am

OVEN TEMPERATURE:

320 °F

FINISH TIME:

11:20 am

M-F 08/06/12

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/06/12 (25)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

\*\*\*\*\*Identify BAG with fine point permanent marker and Stock\*\*\*\*\*

Location:

PE 84/13 (25)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/12

Job Completion



W 08/06/12

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

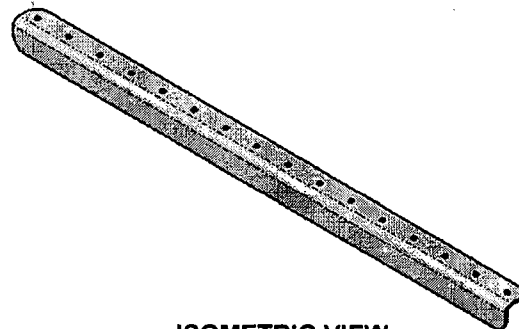
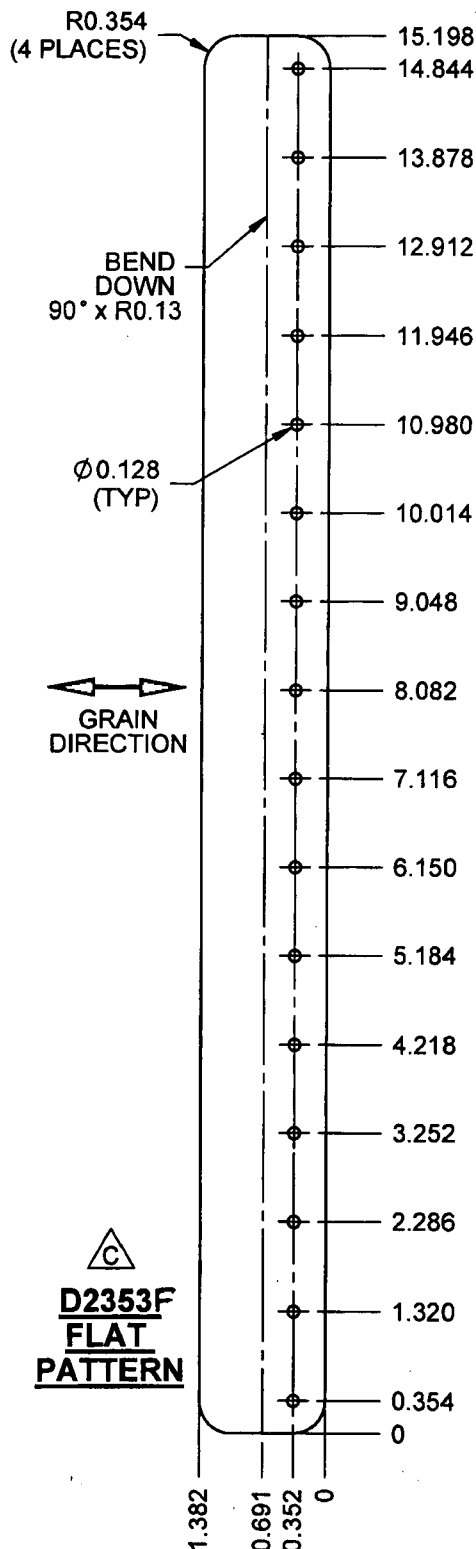
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED [Signature]	DRAWING NO. D2353	REV. C SHEET 1 OF 1
DATE 06.11.13	TITLE STIFFENER	SCALE 1:2	
REV B	DATE 95.02.23	DESCRIPTION ADD TEXT	
C	06.11.13	ADD FLAT PATTERN; ADD NOTES; UPDATE DWG	

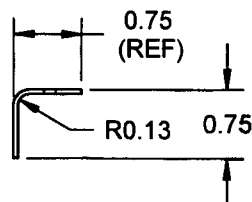


ISOMETRIC VIEW  
SCALE 1:4



NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 SHEET, 0.050 THICK  
PER QQ-A-250/4 OR AMS 4037  
(REF DART SPEC M2024T4S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT  
PER DART QSI 005 4.1  
POWDER COAT BLACK SANDEX (4.3.5.7)  
PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D2353" USING A WHITE  
FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS  
OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX



D2353  
BEND DETAIL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 39639

RELEASED

06-11-28 [Signature]

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